

shg Oct 29

# Work Order ID 63065



Page 1

Tuesday, October 19, 2010 3:26:42 PM

Item ID: D4131-1

Accept



Setup Start



Revision ID:

Item Name: Front Plate

Stop



Start Date: 10/19/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/26/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

*R*

Date: 10-10-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4131

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

304 .050

1-Cut as per Dwg

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

B10-10-21

④

110

QC2- Inspect parts off machine FAI/FAIB

0.00



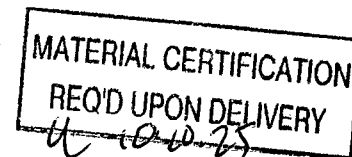
QC

Memo

0.00

Quality Control

B10-10-21



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 63065

Tuesday, October 19, 2010 3:26:42 PM



Page 2

Item ID:	D4131-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Front Plate				Stop	
Start Date:	10/19/2010	Start Qty: 4.00		Cust Item ID:		
Required Date:	10/26/2010	Req'd Qty: 4.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check	0.00				4			10-10-21
130  Packaging Packaging	Identify as per dwg & Stock Location: <i>u</i>	0.00							
	Memo	0.00							
140  QC Quality Control	QC21- Final Inspection - Work Order Release	0.00							
	Memo	0.00							

MF  
10-11-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

Tuesday, October 19, 2010 3:26:46 PM

Work Order ID: 63065



Parent Item: D4131-1



Parent Item Name: Front Plate

Start Date: 10/19/2010

Required Date: 10/26/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.10.06 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	94.8879	0.1807	0.760842			



304/316 .050 Sheet



1810-10-21

Location

Loc Qty

Loc Code

MAT20

94.8879

111743

6.55

112885

0.1679

113062

40.17

115389

48

112885

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

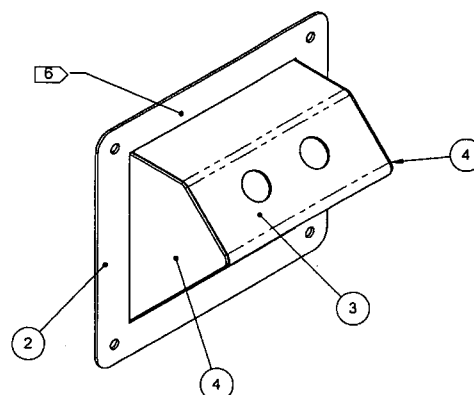
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D4131-041	MANIFOLD ASSEMBLY
2	1	D4131-1	FRONT PLATE
3	1	D4131-3	BASE
4	2	D4131-5	SIDE PLATE



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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 63065

*PS10-10-9*

**D4131-041 MANIFOLD ASSEMBLY**

**RELEASED**  
2010-09-23  
*MM*

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.64 lbs

A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	<i>MD</i>		
MFG. APPR.	<i>MD</i>		
APPROVED	<i>MD</i>		
DE APPR.	<i>MD</i>		
DATE	10.09.16		

**DART AEROSPACE USA, INC.**  
PORT HADLOCK, WA

DRAWING NO. **D4131** REV. A  
SHEET 1 OF 8

TITLE **MANIFOLD ASSEMBLY** SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

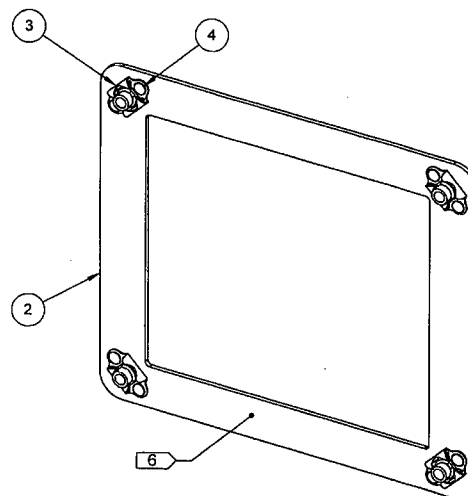
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4131-043	DOUBLER ASSEMBLY
2	1	D4131-7	DOUBLER
3	4	MS21089L3	NUT PLATE
4	8	MS20426AD3-3	RIVET



**D4131-043 DOUBLER ASSEMBLY**

*Wb 43065*

**RELEASED**  
2010-09-23  
*Wb*

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.07 lbs

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>Wb</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>Wb</i>	D4131	SHEET 2 OF 8
APPROVED	<i>Wb</i>	TITLE	SCALE
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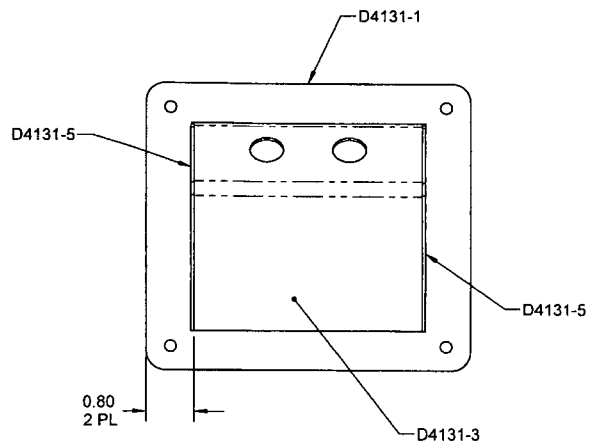
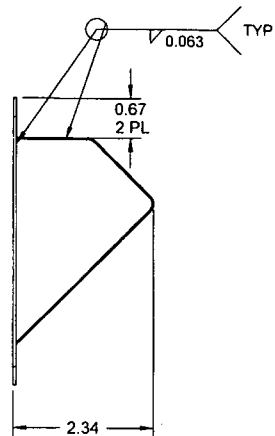
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# **D4131-041 MANIFOLD ASSEMBLY**

*u/b 43065*

**RELEASED**  
2010-09-23  
*NO*

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.64 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>NO</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>SS</i>	<b>D4131</b>	SHEET 3 OF 8
APPROVED	<i>NO</i>	TITLE	SCALE
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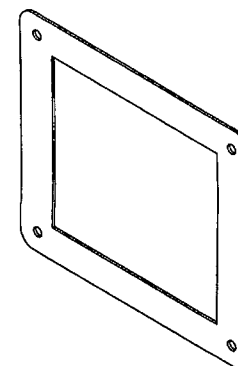
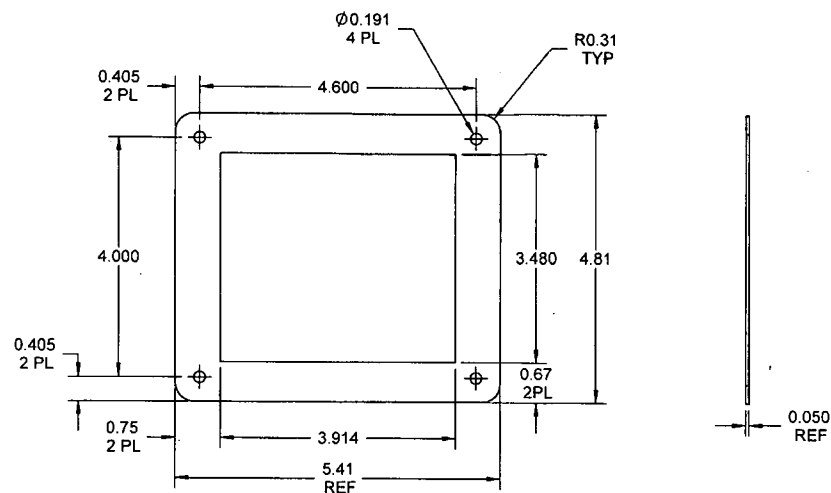
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4131-1 FRONT PLATE**

*cel 63065*

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET  
PER MIL-S-5059  
OR AMS 5513 (304)  
OR AMS 5524 (316)  
OR ASTM A240  
OR ASME SA240  
PER DART SPEC. M304S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.18 lbs

**RELEASED**  
2010-09-23  
*wp*

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>RF</i>	<b>D4131</b>	SHEET 4 OF 8
APPROVED	<i>RF</i>	TITLE	SCALE
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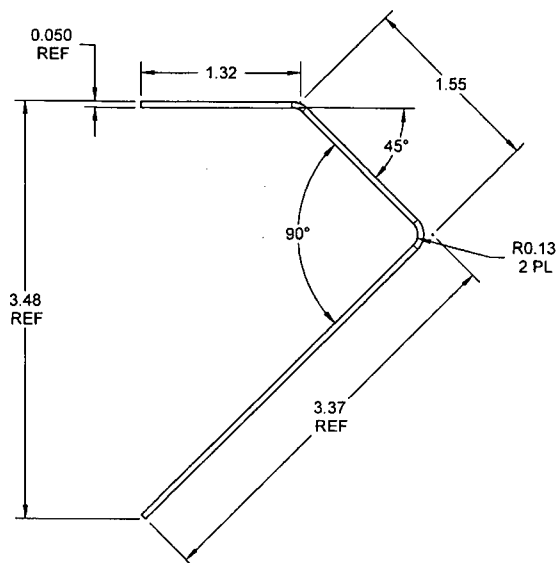
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4131-3 BASE**  
MAKE FROM D4131-3F FLAT PATTERN

*WLO 63065*

**RELEASED**  
R 2010-09-23 D

**NOTES:**

- 1) MATERIAL: MAKE FROM D4131-3F FLAT PATTERN
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.33 lbs

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>140</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>140</i>	D4131	SHEET 5 OF 8
APPROVED	<i>140</i>	TITLE	SCALE
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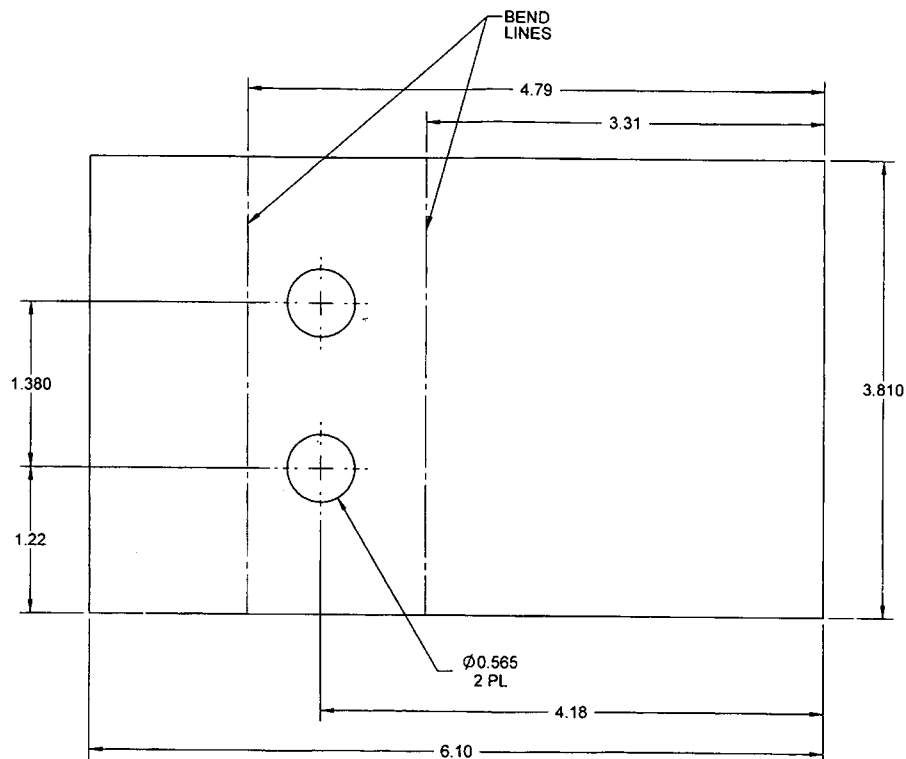
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4131-3F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET  
PER MIL-S-5059  
OR AMS 5513 (304)  
OR AMS 5524 (316)  
OR ASTM A240  
OR ASME SA240  
PER DART SPEC. M304S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.33 lbs

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>10</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>10</i>	<b>D4131</b>	SHEET 6 OF 8
APPROVED	<i>10</i>	TITLE	SCALE
DE APPR.	<i>10</i>	<b>MANIFOLD ASSEMBLY</b>	NTS
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2010-09-23  
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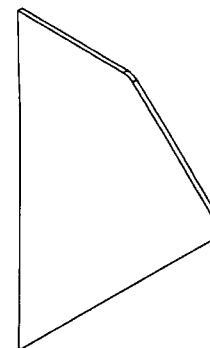
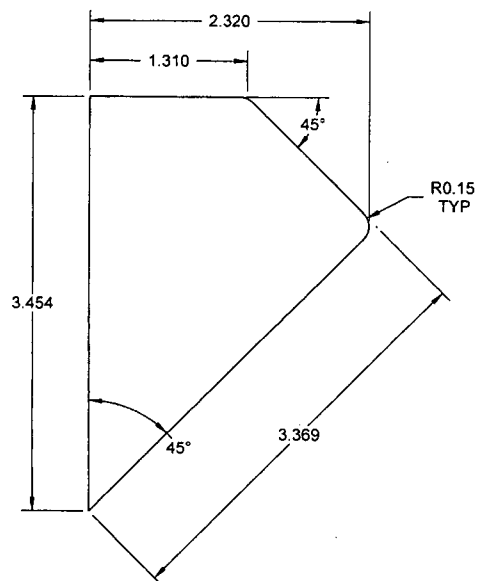
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4131-5 SIDE PLATE**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET  
PER MIL-S-5059  
OR AMS 5513 (304)  
OR AMS 5524 (316)  
OR ASTM A240  
OR ASME SA240  
PER DART SPEC. M304S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>RF</i>	D4131	SHEET 7 OF 8
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	MANIFOLD ASSEMBLY	NTS
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*u10 63065*

**RELEASED**  
2010-09-23  
*MM*

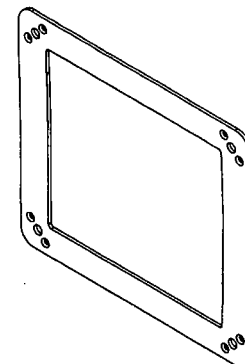
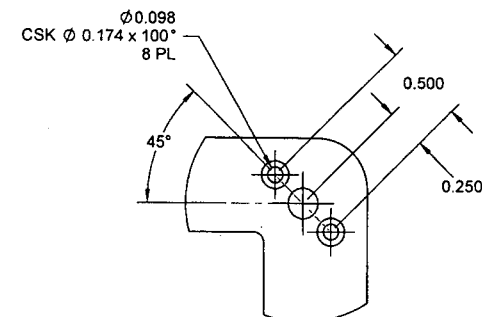
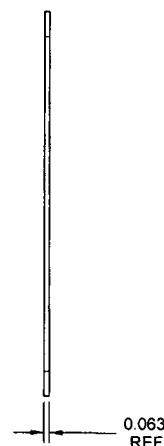
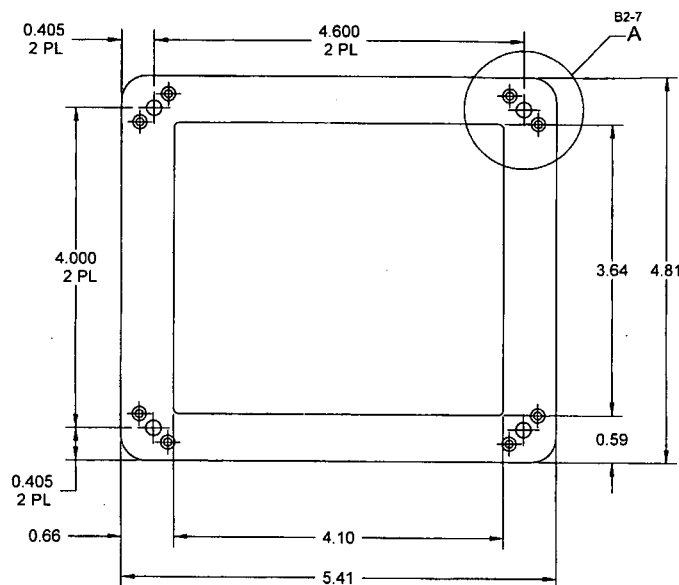
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4131-7 PLATE**

**DETAIL A D5-7 TYPICAL**

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.063 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS4027  
OR ASTM B209  
PER DART SPEC. M6061T6S0.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	MP	DRAWING NO.	REV. A
MFG. APPR.	SS	D4131	SHEET 8 OF 8
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	MANIFOLD ASSEMBLY	NTS
DATE	10.09.16	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

**RELEASED**  
2010-09-23  
WM

*u/o 43065*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Receiving Report

Date: 9/10/13

Batch No: M/12885

Supplier: MAGNA

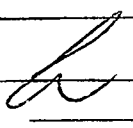
Dart P/O: 10550

Packing Slip: Yes ☒ No ☐  
 Invoice: Yes ☐ No ☒  
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐  
 Waybill Attached: Yes ☐ No ☒ N/A ☐  
 Shipment Complete: Yes ☒ No ☐ N/A ☐  
 QC6 Inspection ☒ N/A ☐  
 Work Order 1710/14 N/A ☒

### Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 

Production/Admin: 09110114  
 Date  
 Received/Costing     
 Initial   

Location





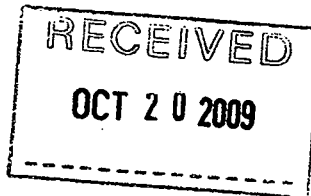
**Magna Stainless**  
5775 Kieran St, Saint-Laurent QC H4S 0A3  
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

# INVOICE

Pg 1 of 1 I017858

SOLD TO:

DART AEROSPACE LTD  
1270 ABERDEEN STREET  
HAWKESBURY , ON  
K6A 1K7



**SHIP TO:**

DART AEROSPACE LTD  
1270 ABERDEEN STREET  
HAWKESBURY , ON  
K6A 1K7

MTR:Y

INVOICE DATE:	10/13/09
ORDER DATE:	10/08/09
SHIP DATE:	10/13/09
ORDER NUMBER:	W019653
PURCHASE ORDER:	P010550

Currency	Sales Person	Ship Via	F.O.B.	Terms
CANADIAN DOLLARS	ERYCK BLAIS	NIR:R-557065-1	PREPAID	NET 30 DAYS

Ln	Back Ordered	Ordered	Unit	Description	Shipped	Price Per	Value
STAINLESS SHEET							
		3	PC	SSH 304 2B 26GA x 48" x 96" L029393 3 PC/73 LB	3 UN	60.00	180.00
		3	PC	SSH 304 2B 20ga x 48" x 96" L029413 3 PC/150 LB	3 UN	115.00	345.00
		4	PC	SSH 304 2B 18ga x 48" x 96" L030411 3 PC/202 LB L028388 1 PC/67 LB	4 UN	135.00	540.00
		4	PC	SSH 304 2B 16ga x 48" x 96" L031195 4 PC/336 LB	4 UN	170.00	680.00

10/14/09 11:47:23

Merchandise:	1,745.00
Surcharges:	
No Tax Costs:	
GST	87.25
Total Due:	1,832.25

Title to the goods sent out on this invoice remains with Magna Stainless Div of CSM ULC until such time as this invoice has been paid in full. Unless otherwise noted terms are 30 days. Interest accrues on all overdue accounts at the rate of 1.5% per month compounded monthly.

Q.S.T. # 1213236471  
G.S.T. # 881565899 RT0001

## Page 1 of 1

All amounts are calculated in domestic currency.

All Vendors PO ID po10550 All Receipt Dates All Line Item Types  
All Item ID/GL/WOs All Rec. Employees All Currencies  
Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Vendor Name		VC-MAG002	Magna Stainless								
PO10550	1		M304S16GA	sf	10/13/09	10/13/09	128.0000	\$5.31	0.0000	0	\$680.00
CAD	No		304/316 Sheet .063	sf	128.0000	Stores		\$680.00	0.0000	0	
			112885								
	2		M304S18GA	sf	10/13/09	10/13/09	128.0000	\$4.22	0.0000	0	\$539.99
	No		304/316 .050 Sheet	sf	128.0000	Stores		\$539.99	0.0000	0	
			112885								
	3		M304S20GA	sf	10/13/09	10/13/09	96.0000	\$3.59	0.0000	0	\$345.00
	No		304/316 .040 Sheet	sf	96.0000	Stores		\$345.00	0.0000	0	
			112885								
	4		M304S26GA	sf	10/13/09	10/13/09	96.0000	\$1.88	0.0000	0	\$180.00
	No		304/316 0.018	sf	96.0000	Stores		\$180.00	0.0000	0	
			SHEET								
			112885								
Total Received Quantity:										448.0000	
Total Qty to Inspect (PO U/M):										0.0000	
Total Reject Quantity:										0.0000	
Total Receipt Value:										\$1,744.99	
Total Balance Due Quantity:										0.0000	



# Magna Stainless

5775 Kieran St, Saint-Laurent, Quebec H4S 0A3  
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

## PACKING LIST

I017858

Page: 1 of 1

SOLD TO:  
DART AEROSPACE LTD  
1270 ABERDEEN STREET

HAWKESBURY, ON  
K6A 1K7  
Contact: CHANTAL

SHIP TO:  
DART AEROSPACE LTD  
1270 ABERDEEN STREET

HAWKESBURY, ON  
K6A 1K7  
Ship Terms: PREPAID



SPECIAL INSTRUCTIONS

Currency		Sales Person	Customer Phone	Customer Fax	Customer PO		
CANADIAN DOLLARS		ERYCK BLAIS	(613) 632-5200	(613) 632-1053	P010550		
Sales Order	Terms		Ship Via		Date Ordered	Date Required	Date Shipped
W019653	NET 30 DAYS		NIR:R-557065-1		10/08/09	10/13/09	10/13/09

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
3		PC	STAINLESS SHEET SSH 304 2B 26GA x 48" x 96"			3
			73 LB / 3 PC	L029393	N69146	3
3		PC	SSH 304 2B 20ga x 48" x 96"			3
			150 LB / 3 PC	L029413	SC18740	3
4		PC	SSH 304 2B 18ga x 48" x 96"			4
			202 LB / 3 PC	L030411	0418904	3
			67 LB / 1 PC	L028388	SC17938	1
4		PC	SSH 304 2B 16ga x 48" x 96"			4
			✓ 336 LB / 4 PC	L031195	A2800233	4
Skids: 1			Total Weight:		828 LB	

Received by:

Date:

Signature:



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO10550

Purchase Order Date 08/10/2009

PO Print Date 08/10/2009

Page Number 1 of 2

Order From :

VC-MAG002

MAGNA STAINLESS  
5775 RUE KIERAN  
ST LAURENT, QC H4S 0A3  
CA

**FAKED**  
08/10/09

Contact Name

Vendor Phone 800 363 6646

Vendor Fax 514 339 1105

Vendor Account Nbr

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M304S16GA	304/316 Sheet .063 4732	13/10/2009 Yes	✓ 128.00 sf	Purolator ground	\$5.3125	\$680.00
		Special Inst:	Purch. Mat: AISI 304/316 SS Sheet ANNEALED 2B finish Spec: MIL-S-5059 or AMS 5513(304) or AMS 5524(316) or ASTM A240 or ASME SA240				
2	M304S18GA	304/316 .050 Sheet	13/10/2009 Yes	✓ 128.00 sf	Purolator ground	\$4.2187	\$539.99
		Special Inst:	SAME AS ABOVE				
3	M304S20GA	304/316 .040 Sheet 3732	13/10/2009 Yes	✓ 96.00 sf	Purolator ground	\$3.5937	\$345.00
		Special Inst:	SAME AS ABOVE				
4	M304S26GA	304/316 0.018 SHEET	13/10/2009 Yes	✓ 96.00 sf	Purolator ground	\$1.8750	\$180.00

Rec'd 13

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

Change Nbr: 1

Change Date: 08/10/2009

# POSCO Mill Test Certificate/검사증명서 M017117

Certificate No./증명서번호: 080910-PRSE-010-001  
Date of Issue/발행일자: Sep., 16, 2008  
Surface Finish/표면마무리: NO.2B

Order No./계약번호: 0008353485

PO No./주문번호: 3363485

Supplier/주문자: DAE WOO INTERNATIONAL CORP.

Commodity/품명: STAINLESS COIL ROLLED COIL

Customer/고객사: MAGNA STAINLESS INC.

Spec. & Type/규격: ASTM-A240-304

Size/치수	Product No. 제품번호	Quantity 수량	Weight 중량 (kg)	Heat No. 재질번호	P.S.T. S.T. D.N.	Tensile 강도 (MPa)	Y.S. 항복 (MPa)	EL 연신 (%)	Hard- ness 경도 HRB	Chemical Composition/화학성분 (%)
										C Si Mn P S Cr Ni Cu Mo N
0.90x1219x0	QEH0799A	1	4.677	SE37928	T	286	643	80	82.0	689 352 1065 283 58 1816 804 442 23 381
0.90x1219x0	QEH0799B	1	4.677	SE37928	B	277	649	80	83.5	639 352 1065 294 59 1816 804 442 23 381
*** Sub. Total (010) ***		2				277	649	80	83.5	
1.20x1219x0	QEH0031B	1	5.649	SC17793	T	281	651	80	82.3	550 392 1031 335 55 1811 804 399 15 392
1.20x1219x0	QEH0031C	1	4.150	SC17793	B	288	663	58	84.7	550 392 1031 335 55 1811 804 399 15 392
1.20x1219x0	QEH0031D	1	4.150	SC17793	T	281	651	80	82.3	550 392 1031 335 55 1811 804 399 15 392
1.20x1219x0	QEH0031E	1	6.528	SC17793	B	288	663	58	84.7	550 392 1031 335 55 1811 804 399 15 392
*** Sub. Total (020) ***		4				288	663	58	84.7	
1.50x1219x0	QEH0030A	1	5.369	SC17797	T	285	643	58	83.7	532 397 1052 307 49 1802 803 388 14 439
1.50x1219x0	QEH0030B	1	5.379	SC17797	B	287	648	58	86.0	532 397 1052 307 49 1802 803 388 14 439
1.50x1219x0	QEH0030C	1	5.225	SC17797	T	285	643	58	83.7	532 397 1052 307 49 1802 803 388 14 439
*** Sub. Total (030) ***		3				287	648	58	86.0	

Position: T: Top, M: Middle, B: Bottom

Tensile Test Direction: Transversal, Gauge Length: 50mm (Rectangular)

Method: 0.2% off-set

Division: L: Lab Analysts

Chemical Composition Unit: 2x1000, 3x1000, 4x1000, 5x1000

T: It is within the standard range (<0.008%) and include trace element

We hereby certify that the material herein has been tested in accordance with the order and specification.

Test Certificate is issued according to EN10204 3.1B.

This Mill Test Certificate cannot be copied for any purpose.

Surveyor To:

POSCO Pohang Works, 5 Dongchon-dong, Nam-gu, Pohang-si, Gyeongsangbuk-do, 790-785, Korea

Chief of material testing section Jo, Won (

W.G. Jo

MO 18855

## POSCO Mill Test Certificate/검사증명서

Certificate No./증명서번호: 081027-PRSE-018-001  
 Date of Issue/발행일자: Oct., 30, 2008  
 Surface Finish/표면마무리: NO.2B

Order No./계약번호: 0003445692

PO No./주문번호: 3445692

Supplier/주문자: DAE WOO INTERNATIONAL CORP.

Commodity/품명: STAINLESS COLD ROLLED COIL

Customer/고객사: MAGNA STAINLESS INC.

Spec &amp; Type/규격: ASTM-A240-304

Spec & Type/규격: ASTM-A240-304																						
Size/치수	Product No. 제품번호	Quantity 수량	Weight 중량 (kg)	Heat No. 재강번호	Position	Tensile/인장시험 YS 0.2% TS EL (MPa) (%)			Hard- ness /경도 HRB	Division	Chemical Composition/화합성분(%)											
											C	Si	Mn	P	S	Cr	Ni	Cu	Mo	N		
0.90x1524xC	QBK0069A	1	4,995	SC19177	T	262	648	59	82.6	S 09/10/04	L	562	420	1050	280	33	1815	804	320	11	403	
0.90x1524xC	QBK0069B	1	4,995	SC19177	B	259	654	61	81.3		L	562	420	1050	280	33	1815	804	320	11	403	
*** Sub Total (010) ***		2				9,990 (kg)																
0.90x1219xC	QGJ0258BA	1	5,980	SC18740	T	273	640	58	85.3		L	505	360	1050	280	31	1835	817	370	13	442	
0.90x1219xC	QGJ0258BB	1	5,960	SC18740	B	281	648	54	86.6		L	505	360	1050	280	31	1835	817	370	13	442	
0.90x1219xC	QGH0799C	1	4,896	SE37926	T	288	643	60	82.0		L	639	352	1065	293	55	1816	804	442	23	381	
*** Sub Total (020) ***		3				15,816 (kg)																
1.50x1524xC	QBK0171A	1	6,341	SC19146	T	273	637	57	83.1		L	587	410	1130	310	31	1819	803	350	10	348	
1.50x1524xC	QBK0171C	1	6,810	SC19146	B	273	637	57	83.0		L	587	410	1130	310	31	1819	803	350	10	348	
*** Sub Total (030) ***		2				13,151 (kg)																
1.50x1219xC	QEJ1008A	1	5,952	SC19200	T	281	636	56	83.8		L	558	410	1040	320	38	1811	806	330	11	372	
					B	285	644	55	85.2													

\* Position - T : Top, M : Middle, B : Bottom  
 \* Tensile Test. Direction : Transversal. Gauge Length : 50mm (Rectangular).  
 YP Method : 0.2% off-set  
 \* Division - L: Ladle Analysis  
 \* Chemical Composition Unit: -2:x1/100, -3:x1/1000, -4:x1/10000, -5:x1/100000  
 \* Tr : It is within the standard range(<0.008%) and include trace element.

We hereby certify that the material herein has been made in accordance with the order and specification.

ORIGINAL

Test Certificate is issued according to EN10204 3.1B.  
 \* This Mill Test Certificate cannot be copied for any purpose.

Surveyor To:

POSCO Pohang Works, 5 Dongchon-dong, Nam-gu, Pohang-si, Gyeongsangbuk-do, 790-785, Korea

W.G. Jo  
Chief of material testing section Jo, Won Gook

# Mill Certificate

Customer : ASA ALLOY  
 Order No : 807090251  
 Steel Grade : TYPE304  
 State of Delivery : SOLUTION TREATED



Changwon Works  
 P.O BOX 95, changwon,korea  
 Telefax:055-268-4133

Inspection No : 20080821100422  
 Specification : ASTM-A240/480  
 Edition : 2006b  
 Date of Issue : AUG.04.2008

No	Case No.	Work No.	Dimension			Surf-ace	Quan-tity	Weight (KG)	Heat No.	Chemical Composition(%)									
										C	Si	Mn	P	S	Ni	Cr	Mo	N	
			Thickness (mm)	Width (mm)	Length (m)					Max	Min	Max	Min	Max	Min	Max	Min	Max	Min
1	C-0112	C08339111-B00	0.500 X 1219		COIL	2B		7.446	N69146	.07	.51	.78	.034	.013	8.02	18.10		.0220	
2	C-1901	C0833A202-B00	0.500 X 1219		COIL	2B		7.997	N70816	.07	.46	.78	.027	.013	8.07	18.17		.0230	
3																			
4																			
5																			
6																			
7																			
8																			

No	Test No.	Mechanical Properties					
		Yield Strength		Tensile Strength	Elonga-tion	Hard-ness	Direction
		0.2%	1.0%	(MPa)	%	(HRB)	Bend Test
		Max	Min	Max	Min	Max	Min
1	9111-1	286		666	63	84	TRANS
2	A202-1	293		680	63	86	TRANS
3							
4							
5							
6							
7							
8							

Remark	
본 검사 증명서에 명시된 규격 용도와 사용시 안전상의 문제가 발생할 수 있으며, 검사 증명서 위.변조시 사형(형법231조)로 불이익을 당하실 수 있습니다.	
We hereby certify, that the Material described above has been tested and complies with the terms of the order contract.	

Changwon Works:  
 66, Shinchon-Dong, Changwon, Kyungnam, Korea. 641-370  
 Ulsan Works:  
 250, Yecheon-Dong, Namgu, Ulsan, Korea. 680-090

C. S. KIM  
 Manager of Quality Assurance Section

68669  
 68669

## MILL TEST REPORT

TA CHEN INTERNATIONAL CORPORATION  
www.tachen.com

This MTR contains 1 page (Page: 1)

MTR#: TXCL1728 Customer#: MAGDOR PO#: P006322 SO#: PE6923  
Item#: 18GA48863042B Bundle#: H295160900 Heat#: 0418904

P006322-0418904

A company  
of ThyssenKrupp  
Stainless

ThyssenKrupp Mexinox



TXCL 1728

## TEST REPORT (CERTIFICADO)

CUSTOMER (CLIENTE)

MEXINOX USA

MILL ORDER No. No. DE PEDIDO	4546 - 8	PACKAGE (EMPAQUE) No. H2951509	DO
CUSTOMER PURCHASE ORDER No.	L26123	DATE (FECHA)	JUN-11-09
CODE PART NUMBER		REPORT (CERTIFICADO) No.	EJ3802

PRODUCT IDENTIFICATION  
IDENTIFICACION DEL PRODUCTO

ITEM No.	COIL No. No. DE ROLLO	PIECES PIEZAS	HEAT COLADA No.	TYPE AND FINISH TIPO Y ACABADO	DIMENSIONS DIMENSIONES	In mm	GROSS WT. PESO BRUTO	lb kg	NET WT. PESO NETO	lb kg
1	693399 AGAA	46	0418904	304 / 2B UNS S30400	48.00 X 88.00 X .0480 1219.20 X 2438.40 X 1.220		3.034		2.862	
							1.376		1.298	

CHEMICAL COMPOSITION  
COMPOSICION QUIMICA (%)

ITEM	C	Cr	Mn	N	Ni	P	S	Si								
1	.0480	18.0400	1.3000	.0450	8.0600	.0280	.0010	.3700								

## OTHER ELEMENTS (OTROS ELEMENTOS)

MECHANICAL PROPERTIES  
PROPIEDADES MECANICAS

ITEM No.	TEST No. No. MUESTRA	D	TENSILE S. R. TENSION	YIELD S. R. FLUENCIA	ELONGATION ALARGAMIENTO	%	HARDNESS DUREZA HRB	
1	A755778 A755778	L	92679 psi 639 MPa	44961 psi 310 MPa	61.2		(HEAD) 83.0 / 83.0	

THIS MATERIAL IS DYNAS 225.872-1 CLASS COMPLIANT. HEAT SOURCE: ITALY

THIS MATERIAL COMPLIES WITH CHEMICAL COMPOSITION ACCORDING TO ASTM A 240/A 240M-08 STD. NOM. AND IT COMPLIES ALSO WITH THE MECHANICAL AND CHEMICAL PROPERTIES ESTABLISHED IN THE FOLLOWING STDs.:  
ASME SA240-95, QQ-S-766-D, MIL-S-5053-D, AMS 55130.

"THIS MATERIAL IS FREE OF MERCURY CONTAMINATION"



We hereby certify that in recognition of the terms and conditions set forth in the EU RoHS Directive -2002/95/EC, we can insure that all of our products and processes fully comply with it.

HECHO EN MEXICO / MADE IN MEXICO

ELABORATED BY  
Jose Luis Vazquez MataPRINTED: 13:48:16 JUL-10-09  
FORMATO No. 38 - 027 - 02 Rev 2





# INSPECTION CERTIFICATE

7324691  
TUC 2122

Shanxi Taigang Stainless Steel CO.,LTD Member  
of Taiyuan Iron and Steel (Group) Co.,LTD

NO.2 jiancaoping, Taiyuan, Shanxi, P.R.China  
TEL: (0351)3013328 FAX: (0351)3017816  
http://www.tisco.com.cn  
E\_mail: tgbxg@tisco.com.cn

## MILL TEST CERTIFICATE

CERTIFICATE NO. T08-692B  
MATERIAL AISI304 NO. 2B FINISH  
SPECIFICATION ASTM A240-04/A480-04, ASME A240/A480  
ASTM A666, AMS 5613/5511  
L/C No.

### CUSTOMER

Ta Chen International, Inc.

### CONTRACT NO.

L22628

### DATE OF ISSUE

20080401

### Product

### Melting furnace

### Inspector's stamp

### Mark of the Manufacturer

SHEET

E+VOD

Shanxi Taiyuan Stainless Steel Co., Ltd

NO.	Heat No.	Coil No.	Batch No.	Quantity	Dimensions (inch)	Weight(Pound)
50	A2800233	KA80261160J10H1	78255692	1	16GA x 48" x 96	4226
51	A2800233	KA80261160J20H3	78255694	1	16GA x 48" x 96	4248
52	A2800233	KA80261160J10H2	78255696	1	16GA x 48" x 96	4248
53	A2800233	KA80261160J20H2	78255700	1	16GA x 48" x 96	4303
54	A2800233	KA80261130P10H4	78255864	1	16GA x 48" x 96	3973
55	A2703845	KA80181530F10H1	78252411	1	14GA x 48" x 120	4707
56	A2703845	KA80181530F10H2	78252414	1	14GA x 48" x 120	4442

### Chemical Composition

Heat No.	C	Si	Mn	P	S	Cr	Ni	Cu	Al	N	Mo	Ti
A2800233	0.042	0.491	1.143	0.026	0.002	18.337	8.012	0.119		0.00	0.093	
A2800233	0.042	0.491	1.143	0.026	0.002	18.337	8.012	0.119		0.00	0.093	
A2800233	0.042	0.491	1.143	0.026	0.002	18.337	8.012	0.119		0.00	0.093	
A2800233	0.042	0.491	1.143	0.026	0.002	18.337	8.012	0.119		0.00	0.093	
A2800233	0.042	0.491	1.143	0.026	0.002	18.337	8.012	0.119		0.00	0.093	
A2703845	0.043	0.538	1.234	0.027	0.002	18.164	8.050	0.218		0.04	0.114	
A2703845	0.043	0.538	1.234	0.027	0.002	18.164	8.050	0.218		0.04	0.114	

### Mechanical Properties (Test temperature :20℃)

Test No.	Tensile R <sub>m</sub> N/mm <sup>2</sup>	R <sub>0.2</sub> Yield <sub>0.2%</sub> N/mm <sup>2</sup>	R <sub>p1.0</sub> Yield <sub>1.0%</sub> N/mm <sup>2</sup>	Elongation		Corrosion Tests	Hardness		
				A5 (%)	A50 (%)		HRB	HV	HRC
78255692-T	640	293			54		87.5		
78255694-T	640	293			54		87.5		
78255696-T	640	293			54		87.5		
78255700-T	640	293			54		87.5		
78255864-T	645	292			53		88.0		
78252411-T	640	299			55		86.5		
78252414-T	640	299			55		86.5		

SPECTROMETER SORTING TEST: OK  
EN 10204-3.1B

Place: Taiyuan

Work Inspector: 李志新

